



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4776-1
Job Sheet 192175



grey sandtex

Part No: D4776-1

Job Qty: 2 pcs

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/18/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 4/15/19

Type: SOLD

Description:

Note: DWG D4776 REV:E IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	2		4/15/19	0.54	1.06	Doosan - 1		<i>BEB 19-03-21</i>
		pcs					Handfinish - 1 - 1		
115	Powdercoat - 1 White GI(A)- B4B	2		4/15/19	0.00	0.02	Powdercoat - 1 - B4B		<i>BL 19-03-27</i>
		pcs					Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		
116	QC 3	2		4/15/19	0.00	0.00	QC 3 - 10		<i>DAS 58 MAR 27 2019 9-89</i>
		pcs					QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		
							QC 3 - 41		
							QC 3 - 51		
							QC 3 - 58		
							QC 3 - 59		
							QC 3 - 68		
							QC 3 - 9		
							QC 3 - 40		
							QC 3 - 19		
130	Packaging 3-1 - Stock - B4B	2		4/15/19	0.00	0.00	Packaging 3 - 1 - B4B		
		pcs					Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

				Packaging 3 - 6 - B4B	DAS 56 MAR 27 2019 9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	2 pcs	4/15/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89 MAR 28 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB167 Rev: _____ & Dwg D4776 Rev: _____ 2 -Deburr per dwg D4776 Descriptions: 115 - (White Gloss(Ref:4.3.5.1) per QSI065 4.3-Alum) MASK .403 ROUND SECTION AS PER DWG START TIME: 2:40 OVEN TEMPERATURE: 326° FINISH TIME: 3:10 M138839. 116 - (QC3- Inspect Part Finish)					

Plex 3/18/19 3:16 PM dart.lacelle.linda

130 - (Identify as per dwg & Stock Location: ST114)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4776-1	Basket Strut Clevis	2 pcs (1 ea)	100-Doosan - 1	<u>5152 159</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D4776-1	2	7	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850		
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428		
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350		
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615		
5	Basket Strut Clevis	1.750Inches ± 0.030	1.780 1.720		
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470		
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060 0.000		
9	Basket Strut Clevis	0.060Inches ± 0.030	0.090 0.030	Radius	
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter	
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter	
12	Basket Strut Clevis	0.410Inches ± 0.030	0.440 0.380	Radius	
13	Basket Strut Clevis	1.130Inches ± 0.030	1.160 1.100		
14	Basket Strut Clevis	0.188Inches ± 0.010	0.198 0.178		
15	Basket Strut Clevis	0.190Inches ± 0.030	0.220 0.160		
16	Basket Strut Clevis	0.500Inches ± 0.030	0.530 0.470		
17	Basket Strut Clevis	0.750Inches ± 0.010	0.760 0.740		
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter	
19	Basket Strut Clevis	0.130Inches ± 0.030	0.160 0.100	Radius	
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750		
21	Basket Strut Clevis	0.160Inches ± 0.030	0.190 0.130		
22	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	

DARI
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S164895



Part: D4776-1

Job No: 192175

Serial No/Batch: S164895

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/21/19